



Dart Aerospace Ltd.
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Canada

Tel (613) 632-5200

D2221

Job Sheet 176266



Part No: D2221

Job Qty: 1 ea

Part Name: Basket Base Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/19/18

Job Tracking No:

Due Date: 5/18/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG REV H IPP Rev:J 05.09.02 Added D3442-1 KJ/JLM IPP Rev:K 08-08-29 revG as per dwg DD verified by:EC IPP Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC IPP Rev:M 08-12-02 revH as per dwg DD verified by:EC IPP Rev:N 10.06.29 added pressure wash DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	5/18/18	5/18/18	0.00	0.00	Start Up Large Fab-2		DG 2018-05-01
100	Large Fab	1 pcs	5/18/18	5/18/18	0.00	10.00	Large Fab 1		CC 18-5-1
110	QC	1 pcs	5/18/18	5/18/18	0.00	0.00	QC9		PL
120	QC	1 pcs	5/18/18	5/18/18	0.00	0.00	QC5		CPL
125	HandFinish	1 pcs	5/18/18	5/18/18	0.00	0.35	HandFinish2		REB 18-05-15
130	Powdercoat	1 pcs	5/18/18	5/18/18	0.00	0.81	Powdercoat2		BL 18-5-16
140	QC	1 pcs	5/18/18	5/18/18	0.00	0.00	QC3		HL 18-5-12
150	Packaging	1 pcs	5/18/18	5/18/18	0.00	0.00	Packaging3		ME 18-5-16
160	QC21-SA	1 Ea	5/18/18	5/18/18	0.00	0.00	QC21		MAY 17 2018 18/05/17

Part Op 100 - 1- assemble all ribs and both D2581 in DT9444 jig, weld as per dwg D2221 2- remove basket from jig and weld
Descriptions: D3442-1 shims and D2232-3 hinges as per dwg D2221 3- tack weld mesh on basket as per dwg D2221 A/R ER316 S.S.
Rod Batch: *****PLEASE NOTE SEE DWG*** IF MAKING -141/-041A CUT BUSHING ON BASE BOTH ENDS, OR -143/-043A CUT BUSHING ON ONE SIDE ONLY OF BASKET BASE AS PER DWG
130 - 1- Plug holes prior to 1ST COAT: START TIME: 12:00 OVEN TEMPERATURE: 375° FINISH TIME: 12:00
***** 2nd coat if necessary ***** 2ND COAT: FINISH TIME: 12:00

M 134760

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2221-1	Rib	1 Ea (1 ea)	90-Start up Operation	8F160533
D2221-5	Rib	2 Ea (2 ea)	90-Start up Operation	F160534
D2221-7	Rib	1 Ea (1 ea)	90-Start up Operation	5006413
D2232-3	Basket Hinge	2 Ea (2 ea)	90-Start up Operation	503173
D2235-1	Basket Rib	2 Ea (2 ea)	90-Start up Operation	5037237
D2581	Mounting Bracket	2 Ea (2 ea)	90-Start up Operation	5042562
D3442-1	Shim	2 Ea (2 ea)	90-Start up Operation	F142837
D3825-041	Rib Assembly (Basket End)	2 Ea (2 ea)	90-Start up Operation	5039313
D3826-041	Rib / Gusset Assembly	2 Ea (2 ea)	90-Start up Operation	8F160526
D3827-041	Rib Assembly (Inboard)	1 Ea (1 ea)	90-Start up Operation	F1605209
D3833-1	Mesh (Base End Face)	2 Ea (2 ea)	90-Start up Operation	5039984
M304EX0.75-16F	Expanded Metal Flat SS	26.6000 sf (26.6 ea)	90-Start up Operation	5060245

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2221-1	1	7	0
	D2221-5	2	2	0
	D2221-7	1	6	0
	D2232-3	2	5	0
	D2235-1	2	12	0
	D2581	2	72	0
	D3442-1	2	15	0
	D3825-041	2	4	0
	D3826-041	2	6	0
	D3827-041	1	5	0
	D3833-1	2	7	0
	M304EX0.75-16F	27	1,120	0
Part Specifications				
Specifications could not be found.				

Plex 4/19/18 11:23 AM Dart.Gagnon.Michelle



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Container No: S067193



Part: D2221

Job No: 176266

Serial No/Batch: S067193

Revision:

Inspector:

Date: 05/01/18